	in the second market	WORK ORDER NOW CONCORMANCE	CONCORMANCE / HODATE		レダス
QA Closed:	Date: 13.	7-12	7	Work Order update only	AEROSPAC
Work Order:	448801	DISPOSITION	AGAINST DE	AGAINST DEPARTMENT/PROCESS	
Part No.	D3264-	Rework	Skid-tube Crosstube Small Fab	Water Jet Prod. Eng. Coor.	Engineering Quality
NCR No.	15-2837	Use-as-is X Suspected Unapproved	Thermoforming Finishing Large Fab Composite	Rec/Store/Packaging Supplier	Other
Root	Date Sten Otv	Description of work order update	Initial Action Chief Eng Description	Sign & Verification	OC Inspector
	A S	Top odyses of 2525 rad	THIS WILL NOT PRESENT		3
Equip/Tooling		stightly bent from		7.07.00	8
Handling/Pre		tightening of the vise	LINGOLD V	,	8-80
Operator		RC Tools (Sc. /	JANDERS OHL OLMO 80'to'CI	0 0	3/2/28
Offset/Setup Process		(act of sets tour holds		150100	
Supplier					
Training		* * * * * * * * * * * * * * * * * * *			
Unapproved	·				
			FAULT CATEGORY		
Landing Gear	ear	General]		
	Bending Centre Not Concentric	BOM/Route	Grain Folio/Program	Outside Dimensions Over/Under tolerance	Set-up
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
L	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pullec
Γ	Crushing	Countersink	Misaligned/off center	Positioned Wrong	-
<u> </u>	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other
	Inspection Strip in Tube	Drawing	Misread		
Ι	Marks/Chatter	Drill Holes	Off-set		
	Turning Sequence	Finish	Out of Calibration		
	Wave/Twist in Tube	Fit/Function	Out of Sequence		

Date: 13/18/06

102844

Page 2

140 HandFinish	140	QC QC Quality Control	130	*420* QC Quality Control	Work Center ID	Sequence ID/	Approvals:	Reference:	Start Date: 6/11/13 Required Date: 6/11/13	Revision ID: Item Name: B	יי	June-12-13 9:15:15 AM
Memo	Chemical Conversion Coat per QSJ005 4.1	Memo	QC8- Inspect parts - second check	Memo	QC2- Inspect parts off machine FAI/FAIB	Operation*	Process Plan: I		6/11/13 Start Qty: 8.00 6/11/13 Req'd Qty: 8.00	Bracket	D3264-I	15 AM
0.00	er QSJ005 4.1 0.00	0.00	theck 0.00	0.00	ne FAI/FA[]3 0.00	Set Up/	Date: SPC (Y/N):		ૐ ૐ		Accept	
D		D. 13 07 08	-	ξ., (5),		Tool ID Tool # Plan	Date:		Cust Item ID: Customer:		*N900040100*	
8 NB/3-1-1	0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	0 4	0	# 15-0x-06	DAN CO Summer Stamp	ept Reject Reject	Stop *ZR>*	Run Start *ND1*		Stop	* Setup Start *NS1*	

Hand Finishing

													L a	Tran	- F	1 2	off.	- Op	Mat	E E	Doc/Da						€]ஓ
		<u> </u>	<u> </u>	<u> </u>	Ī	Ι	Γ-	Γ-	ı	Γ	Landing Gear		Unapproved	Transport	Supplier		Offset/Setup	Operator	Material	Equip/Tooling X	Doc/Data	Cause	Root	NCR No		Part No.	Work Order:	QA Closed:
Wave/Twist in Tube	Turning Sequence	Marks/Chatter	Inspection Strip in Tube	Heat Treat	Crushing	Cuffs	Crimp/Kink/Ripple/Wave	Cracks	Centre Not Concentric	Bending	Gear			I, I			I	13,03.06			<u> </u>	Date	1	NCR No. 10 000	י צי		102844	R
ist in Tu	equence	atter	ո Strip ir	-			k/Ripple		t Conce						3	Š	۶ ج	<u> </u>	N.			Step)	Q	とい	D3264-1	644	Date: \
be	,,,		1 Tube				e/Wave		ntric									É	5 ·			Qty) <u>K</u>	5			13
Fit/Function	Finish	Drill Holes	Drawing	Cut Too Short		•	,	•	1	-	1		Devic / toling	Ec Cock of Better Wildow	TO 0.125",	TANKER BETWEEN O. 110	To NO COUNTRY AND	SHAWN DIN HITHCHED BUS	SI CHE O.125 JULICATES AS	IN JAWS (LESCITS:	PART HELD TOO TIGHT	or non-conformance	Description of work order update	Suspected Unapproved	Use-as-is	Rework Scrap	DISPOSITION	7-17
			Ļ	<u> </u>	<u> </u>	<u> </u>	<u>_</u>		<u>_</u>	<u>_</u>]	FAU	_					<u>Ş</u> .	·		····	Chi			<u></u> K	<u> </u>]	
Out of Sequence	Out of Calibration	Off-set	Misread	Mislabeled	Misaligned/off center	Instructions Incomplete/Unclear	Inspection Incomplete/Unqualified	Hardware	Grain	Folio/Program		FAULT CATEGORY		IF THICKNESS IS 0,110"+.	Should arre deal		POSITIVE. THEREPORD	7145 11 SH APIL 180°45'4	22 CALCULATION SHOWS THAT		PER ATTACKS SHEET 5	Chief Eng Description		Large Fab Composite		Skid-tube Crosstube Machining Small Fab]	
		·		Power Loss/Surge	Positioned Wrong	Part Moved	Part Lost/Missing	Part Incorrect	Over/Und	Outside []	ı		<u>.+</u>	26	<u>. </u>	4 <u>2</u> 2		THAT	, 13-07°	5 A	Date	Sign &				AGAINST DEPARTMENT/PROCESS	Work Order
				<u> </u>	d Wrong	red	<u> </u>	rrect	Over/Under tolerance	Outside Dimensions	1						101100	257			300 50 50 50 50 50 50 50 50 50 50 50 50 5	Verification		Supplier	Rec/Store/Packaging	Water Jet Prod. Eng. Coor.	NT/PROCESS	Work Order update only
				Other		Wrong Stock Pulled	Weld	Temperature/Cure	Set-up	Pressure/Forced	•					5	12/2/		\$ -40	(08 8		QC Inspector	•		Other	Engineering Quality]	AEROSPACE

Date: 15/07/23

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

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Packaging

Packaging

Memo

0.00

												Unapproved	Transport	Training	Supplier	Process	Offset/Setup	Operator	Material	Handling/Pre	Equip/Tooling	Doc/Data	Design	Cause	Root					Worl	QA Closed:
_	1	_	_	_	Г	<u> </u>	_		Ι	Landing Gear		oved	ă T		т <u>-</u>	r -	etup	<u> </u>	<u>-</u>	g/Pre	oaling I	េ		ISE	ŏ	RCN NO.		Part No.		Work Order:	sed:
7	I Mark	Inspe	Heat Treat	Crushing	Cuffs	Crimp	Cracks	Centr	Bending	Gear			<u> </u>	<u></u>	1	l	<u>l</u>	L				<u> </u>	\Box	Date			,	ب ا		. :	
	Marks/Chatter	Inspection Strip in Tube	Treat	gri		Crimp/Kink/Ripple/Wave	ı	Centre Not Concentric	g D													_									
	7	ip in Tut				pple/w		ncentrio									<u></u>						┥	Step C							Date:
		ĕ				ave		.,						-										Ωŧ/	D						
	Drill Holes	Drawing	Cut Too Short	Countersink	Contamination	Burrs	Broken/Damage/Defect	BOM/Route	Bend	General														or non-conformance	Description of work order update	paspected citabbiosed	Use-as-is	Scrap	Rework	DISPOSITION	
	Off-set	Misread	Mislabeled	Misal	Instru	Inspec	Hardware	Grain	Folio/		FAULT CATEGORY													Chief Eng	Initial		Ther			. <u> </u>	
	~	ă.	peled	Misaligned/off center	Instructions Incomplete/Unclear	Inspection Incomplete/Und	are .		Folio/Program		TEGORY													g Description	Action	raige fau	Thermoforming	Machining	Skid-tube		la de la companya de
						/Unqualified]													,	ption	on	composite	Finishing	Small Fab	Crosstube	AGAINST DEPARTMENT/PROCESS	Wo
			Power Loss/Surge	Positioned Wrong	Part Moved	Part Lost/Missing	Part incorrect	Over/Under tolerance	Outside Dimensions															Date	Sign &		Rec/Sto	Pro		ARTMENT	rk Order u
		:	'Surge	Wrong	<u> </u>	issing	<u> </u>	· tolerance	nensions	1														Verification		- Supplied	Rec/Store/Packaging	Prod. Eng. Coor.	Water Jet	/PROCESS	Work Order update only
			Other	J	Wrong Stock Pullec	Weld	Temperature/Cure	Set-up	Pressure/Forced	J				-										QC Inspector			Other	Quality	☐ Engineering		

Date:

4

102844

Page 4

.; |1 |1

Item Name: Revision ID: Item ID: June-12-13 9:15:15 AM D3264-1 Bracket Accept *N900040100* Setup Start *NS1* *Stop *NS2*

* * ж ж

Cust Item ID:

Customer:

Date:

Date:

Run Start *NR1*

NR2

Reject Reject Insp.

Qty Number Stamp

Memo

[∻]18∩*

Sequence ID/ Work Center ID

Description Operation

QC21- Final Inspection - Work Order Release

0.00

Approvals:

Process Plan:

Date: Date:

SPC (Y/N): Tooling:

Set Up/

Tool ID

Tool# Plan

Code

Accept Qty

Run Hours

Reference:

Required Date: 6/11/13

Req'd Qty: 8.00 Start Qty: 8.00

Start Date:

6/11/13

Quality Control

0.00

MB-07/0

QA Closed:		Date:						Wo	Work Order update only	date only	
Work Order:	:			····	DISPOSITION			AGAINST DEPARTMENT/PROCESS	ARTMENT	/PROCESS	
Part No.				<u>.</u>	Rework	 X	Skid-tube	Crosstube Small Fab	Pro	Water Jet Prod. Eng. Coor.	Engineering Quality
NCR No.					Use-as-is Suspected Unapproved	Thermo	Thermoforming	Finishing Composite	Rec/Sto	Rec/Store/Packaging Supplier	Other
	,										
Root	O _{sto}	\$ 	<u></u>)escrip	Description of work order update	Initial	Action Description	ortion on	Sign &	Verification	OC Inspector
Design			_			,					\dashv
Doc/Data											_
Equip/Tooling					_						
Handling/Pre											
Material											
Operator						·					
Offset/Setup		·						<u>.</u>			
Process											
Supplier											
Training											
Transport											
Unapproved			L	İ							
			i			FAULT CATEGORY	GORY				
Landing Gear	iear		-2]	General	J]		1	J
	Bending			<u>B</u>	Bend	Folio/Program	ogram		Outside Dimensions	ensions	Pressure/Forced
	Centre Not Concentric	Concent	tric	<u></u>	BOM/Route	Grain		<u> </u>	Over/Under tolerance	tolerance	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect	Hardware			Part Incorrect	2	Temperature/Cure
	Crimp/Kink/Ripple/Wave	/Ripple/	Wave	٣	Burrs	Inspection	Inspection Incomplete/Unqualified		Part Lost/Missing	ssing	Weld
	Cuffs			<u></u>	Contamination	Instructio	Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing			<u></u>	Countersink	Misalign	Misaligned/off center		Positioned Wrong	Vrong	J
	Heat Treat			<u></u>	Cut Too Short	Mislabeled	ā		Power Loss/Surge	Surge	Other
L	Inspection Strip in Tube	Strip in T	ube	Ŀ	Drawing	Misread					
l	Marks/Chatter	tter		Ē	Drill Holes	Off-set				!	
	Turning Sequence	quence		<u> </u>	Finish	Out of Calibration	libration				
	Wave/Twist in Tube	tin Tube			Fit/Function	Out of Sequence	quence				

_ Date:

.·Pičklist Print

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June-12-13 9:15:14 AM

Work Order ID: 102844

Parent Item: D3264-1

Parent Item Name: Bracket

IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name M6061T6B1.250X04.500 Comments: Replacement Item ID Mfg/ Purch

6061-T6 Bar 1.25 X 4.50

Purchased

No No Item Bin

Primary Location

Location Last

Route Seq ID

Unit of Oty on Measure Hand

Qty per Kit Total

9

Status

Issued Issued Date

Qty

3.2534

Loc Code

MAT004 Location 09121 112628 121380 × 1.77 Loc Otv 1.4834 3.2534

Start Date: 6/11/13

!

Required Date: 6/11/13

Start Qty: 8.00

Required Qty: 8.00

TY 73 07-02

Page I

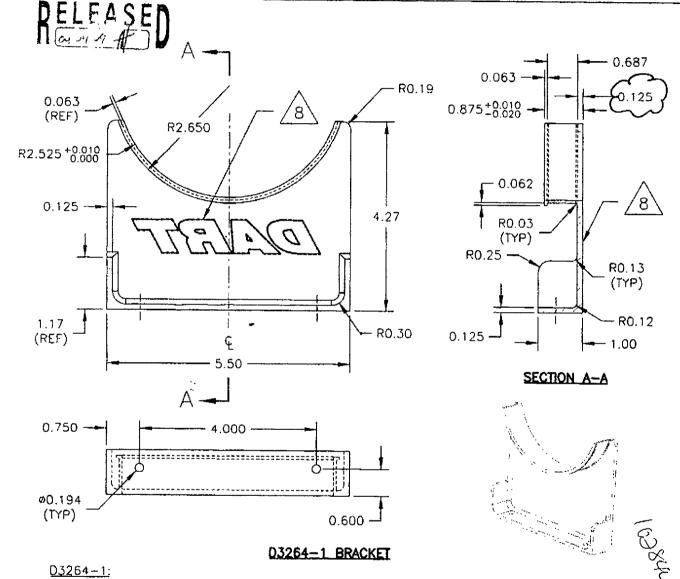
QA Closed:		Date:				Work Order update only	
Work Order				DISPOSITION	AGAINST	AGAINST DEPARTMENT/PROCESS	
Part No.				Rework · Scrap	Skid-tube Crosstube Machining Small Fab	Water Jet Prod. Eng. Coor.	Engineering Quality
NCR No.				Use-as-is Suspected Unapproved		Rec/	Other
			-				
Root	Date	Step Q	Qty De	Description of work order update or non-conformance	Initial Action Chief Engl Description	Sign & Date Verification (QC Inspector
Design							
Doc/Data							
Equip/Tooling							
Handling/Pre	•						
Material		·	-				
Operator	•						
Process						- 1	
Supplier							
Training							
Transport						_	
Unapproved							!
					FAULT CATEGORY		
Landing Gear	Gear		•	General]	
	Bending		···	Bend	Folio/Program	Outside Dimensions Press	Pressure/Forced
	Centre Not Concentric	oncentrio		BOM/Route	Grain	Over/Under tolerance Set-up	ō
<u> </u>	Cracks			Broken/Damage/Defect	Hardware	Part Incorrect Temp	Temperature/Cure
	Crimp/Kink/Ripple/Wave	∛ipple/w	ave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing Weld	
	Cuffs			Contamination	Instructions Incomplete/Unclear	Part Moved Wron	Wrong Stock Pulled
<u></u>	Crushing			Countersink	Misaligned/off center	Positioned Wrong	
	Heat Treat			Cut Too Short	Mislabeled	Power Loss/Surge Other	*
	Inspection Strip in Tube	rip in Tuk	ĕ	Drawing	Misread		
1	Marks/Chatte	er		Drill Holes	Off-set		
<u> </u>	Turning Sequence	ence		Finish	Out of Calibration		
	Wave/Twist in Tube	n Tube		Fit/Function	Out of Sequence		

Date:





	DESIGN	ORAWN BY		OSPACE LTD ONTARIO, CANADA
	CHECKED C#	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
Ţ	DATE		TITLE	SCALE
1	04.04.20		BRACKET	1:2
	A	04.04.20	NEW ISSUE	



- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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QA Closed:	Date:			Work Order update only	
Work Order:		DISPOSITION	AGAINST	AGAINST DEPARTMENT/PROCESS	
Part No.		Rework Scrap	Skid-tube Crosstube Machining Small Fab	Water Jet Prod. Eng. Coor.	Engineering Quality
NCR No.		Use-as-is Suspected Unapproved		Rec/	Other
·			[[[
Root		Description of work order update	Initial Action	Sign &	
Cause Date	te Step Qty	or non-conformance	Chief Eng Description	Date Verification	QC Inspector
Design					
Doc/Data					-
Equip/Tapling					
Handling/Pre					
Material					
Operator					
Offset/Setup			_		
Process					
Supplier					
Training					
Transport					
Unapproved					
		71	FAULT CATEGORY		:
Landing Gear		General]]	1
Bending	ling	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Cent	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	S	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crim	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs		Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Crushing	ning	Countersink	Misaligned/off center	Positioned Wrong	
Heat	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other
Inspe	Inspection Strip in Tube	Drawing	Misread		
Mark	Marks/Chatter	Drill Holes	Off-set		
Turni	Turning Sequence	Finish	Out of Calibration		
Wave	Wave/Twist in Tube	Fit/Function	Out of Sequence		
H:/FORMS/Quality Assura	H:/fORMS/Quality Assurance\approved QA/NCRWO RevH	\evH			
H:/FORMS/Quality Assura	e/Twist in Tube nce\approved QA/NCRWO I	<u> </u>	Out of Sequence		İ

DART AEROSPACE LTD	Work Order:	100844
Description: Bracket	Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First A	ticle	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.690			nen	27-4
0.063	+/-0.010	,061		_		
0.125	+/-0.010	.117		_		
0.875	+0.010/-0.020	,879				<u> </u>
0.062	+/-0.010	-061				
R0.03	+/-0.030	.030				
R0.13	+/-0.030	.130				
1.00	+/-0.030	1,004				
0.125	+/-0.010	.124				
0.600	+/-0.010	500				
4.000	+/-0.005	3.998				
0.750	+/-0.010	.750				
Ø0.194	+0.005/-0.000	.195				
5.50	+/-0.030	5.500		_		
0.125	+/-0.010	-125				
0.063	+/-0.010	,063				
R0.25	+/-0.030	.220				
4.27	+/-0.030	4.269				
R0.30	+/-0.030	. პაი				
						10 T

Measured by:	Audited by: 12.6 DAS	Prototype Approval:	N/A
Date: 13 - 87 06	Date: 13/04/08 8-89	Date:	N/A

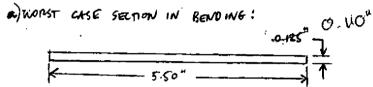
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	,
B !	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
С	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	1/2

QA Closed:		Date:					W	Work Order update only	date only	
Work Order:		:		DISPOSITION			AGAINST DEPARTMENT/PROCESS	PARTMENT/	'PROCESS	
1				Rework		Skid-tube	Crosstube	,	Water Jet	Engineering
rdit No.		ļ		Use-as-is	Thermo	Thermoforming	Small Fab Finishing	Rec/Stor	Rec/Store/Packaging	Other
NCR No.				Suspected Unapproved		Large Fab	Composite	i,	Supplier	
Root			_	Description of work order update	Initial	A	Action	Sign &		
Cause	Date	Step	aty	or non-conformance	Chief Eng	Des	Description	Date	Verification	QC Inspector
Design			-							
Doc/Data				,			<u>ئ</u>			
Equip/Tooling				,	,	•	· .		-	•
Handling/Pre				; ;	<u>,</u>		>	š		
Material			_	ľ		•	,	1	<u>.</u>	
Operator			<u> </u>		•					-
Offset/Setup		·				•	•			
Process						•	/ / /			-
Supplier				•						
Training										
Transport					•					
					FAULT CATEGORY	GORY				
Landing Gear	ear			General				4		
	Bending			Bend	Folio/Program	ogram		Outside Dimensions		Pressure/Forced
<u> </u>	Centre Not Concentric	ot Concen	tríc	BOM/Route	Grain			Over/Under tolerance	ì	Set-up
	Cracks			Broken/Damage/Defect	Hardware			Part Incorrect		Temperature/Cure
	Crimp/Kink/Ripple/Wave	ık/Ripple/	wave)	Burrs	Inspectio	Inspection Incomplete/Unqualified	Unqualified	Part Lost/Missing	Γ	Weld
	Cuffs			Contamination	Instructio	Instructions Incomplete/Unclear	/Unclear	Part Moved		Wrong Stock Pulled
	Crushing			Countersink	Misalign	Misaligned/off center		Positioned Wrong	rong	
	Heat Treat	7		Cut Too Short	Mislabeled	ă		Power Loss/Surge		Other
	Inspection Strip in Tube	ን Strip in ٔ	Гubе	Drawing	Misread					
	Marks/Chatter	atter		Drill Holes	Off-set				:	
	Turning Sequence	equence		Finish	Out of Calibration	libration				
	Wave/Twist in Tube	ist in Tub	le l	Fit/Function	Out of Sequence	quence				
H:/FORMS/Quality Assurance\approved QA/NCRWO RevH	\ssurance\a	pproved QA	/NCRWO F	ёvН						
,										

Date:

DESIG	*#	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO	
CHEC	(ED P	APPROVED	DRAWING NO. SR- D412-706-1	REV. A SHEET 5 OF 5
DATE	04.10.	27	TITLE STILESS ILEPORT	SCALE MTS
Α	04	. 10.27	NEW ISSUE	

3.3 D3264-1 BRACKET ANALYSIS



$$F_{tu} = 38 \text{ Ksi (for QQ-A-200/8)}$$

$$MS = \frac{38}{24.4} - 1 = \frac{0.56}{0.06} - 0K \text{ 0.06}$$

6) LOCALIZED LOADING:

HIGHEST BOLT LOAD =
$$44 \%$$
 (SEE SECTION 3.2)

CONSIDER LOAD ACTS EVER A WIDTH OF $4D = 0.76\%$

.. $T = \frac{1}{12}bh^3 = \frac{1}{12}(0.76\%)(0.125\%)^3 = 0.000124$ in 4
 $C = 0.063\%$
 $M = (44\%)(0.475\%) = 21$ in 16

 $6 = Mc/T = (21)(0.063\%)/0.000724$ in $4 = 10.7$ ksi

Fin = $\frac{38}{10.7} = \frac{2.6}{10.7} = \frac{2.6$

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